



Dart Aerospace Ltd.
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Canada

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D2850-1
Job Sheet 203092



Part No: D2850-1

Job Qty: 20 pcs

Part Name: End Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Due Date: 11/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP B 98.12.07 Changed folio DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	20 pcs	11/28/19	11/28/19	0.00	0.17	Bandsaw - 1	52 19/12/09
110	HAAS 4 Axis - B4B	20 pcs	11/28/19	11/28/19	0.20	13.99	HAAS - 1 - B4B	9-89 19-12-11
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
130	QC 8	20 pcs	11/28/19	11/28/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	9-19/12/12
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	



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Container No: S239496



Part: D2850-1

Job No: 203092

Serial No/Batch: S239496

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/11/19

140 Packaging 3-1 - Stock - B4B 20 pcs	11/28/19	0.00	0.00	QC 8 - 61		
				Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B	DAS	
				Packaging 3 - 19 - B4B	24	
				Packaging 3 - 20 - B4B	9-89	
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B	DAS	
150 QC 21 - SA	20 pcs	11/28/19	0.00	0.00	QC 21 - SA - 21	21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	DEC 1 3 2010

Part Op 100 - (Bandsaw) Cut blanks: 3.8"
Descriptions: 110 - (HAAS CNC Vertical Machine) Machine per Folio D2850-1 Deburr and Tumble
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL ***
150 - (QC21- Final Inspection - Work Order Release)

DEC 17 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	6 ft (.3 ea)	100-Bandsaw - 1	5166874 5150600 5234878
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	6	18	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	High Float Step End Bracket	1.720inches + 0.000 - 0.030	1.720 1.690	1.718	
2	High Float Step End Bracket	0.178inches ± 0.010	0.188 0.168	0.178	
3	High Float Step End Bracket	0.100inches ± 0.030	0.130 0.070	0.095	
4	High Float Step End Bracket	30.000Degrees ± 0.500	30.500 29.500	30°	
5	High Float Step End Bracket	2.150inches ± 0.030	2.180 2.120	2.152	
6	High Float Step End Bracket	0.375inches + 0.010 - 0.100	0.385 0.275	0.371	
7	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115	0.120	
8	High Float Step End Bracket	1.000inches ± 0.030	1.030 0.970	1.0035	
9	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115	0.125	
10	High Float Step End Bracket	19.200Degrees ± 0.500	19.700 18.700	19.2°	
11	High Float Step End Bracket	0.125inches ± 0.010	0.135 0.115	0.125	
12	High Float Step End Bracket	0.750inches ± 0.010	0.760 0.740	0.750	
13	High Float Step End Bracket	0.600inches ± 0.010	0.610 0.590	0.601	

Plex 11/8/19 10:08 AM Dart.lajeunesse.marie

DAS
73
9-89 19-12-10

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Completed By		Lead hand / Supervisor			
				QC / QA Coordinator			